<b>Work Order I</b> January-15-14 1:19:		9 0 0	37-1	*1	11	594*							Page 1
Item ID: D35 Revision ID: Item Name: Wea	37-1 rpad	BI	1594	Accept		*N900	<b>040</b>	100	<b>)*</b> \$	Setup	Start Stop	*N.9	
Start Date: 1/15 Required Date: 2/07 Reference:		rt Qty: 50.00 q'd Qty: 50.00	*50* *50*	+60	> <b>∦</b>	Cust Item I	D:						
Approvals: Pro	ocess Plan:	MLJ	Date: 14-01-17	Tooling:		Da	nte:	-	F	Run	Start	*NF	₹1*
	C:		Date:	SPC (Y/N)	:	Da	ite:				Stop	*NI	₹2*
Sequence ID/ Work Center ID		ration cription		Set Up/ Run Ho	urs	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Revision	Nbr											
D3537	Rev C												<b>3</b>
*1 \\ \*\ \\ \\ \\ \\ \\ \\ \\ \\ \\ \\ \\	FLO'	W WATER JET  Memo  1-Cut as pe  if necessary	or Dwg D3537Dwg Rev: <b>(</b>	0.00 0.00 Prog Rev:	C	_ 2-Deburr			60		<b>&gt;</b>	. # 1	Ac 14.01.26
110	QC2	- Inspect parts off r	nachine FAI/FAIB	0.00									
*110* QC Quality Control		Мето		0.00					60		<b>&gt;</b>		<u>Ae</u> 14.01.20
120	QC8	- Inspect parts - sec	cond check	0.00	68-6				(ub				
*120* QC Quality Control		Memo		0.00		14/01/27			(460	ノ	<del></del>		

			DQA:	Date:	
NCR:	Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE	'	_	

											QA Closea:	Date	
Work Orde	er:					DISPOSITION							
Part N						Rework Scrap Use-as-is Work Order Update		f Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	ł	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
							,						
Root					Descri	ption of work order update	lı	nitial	Ac	ction	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data		ļ											}
Equip/Tooling	Ш												
Operator	Щ												
Material	Щ												
Setup			, , , , , , , , , , , , , , , , , , ,						1				
Other	Ш												
Process	Ш												
Supplier	Ш												
Training	Ш	i											
Unapproved								.=.	<u> </u>				
						<del></del>	AUL'	T CATE	GORY	·	. · · · · · · · · · · · · · · · · · · ·	~	
Landi						General	_			<b></b>	•	<del></del>	<b>-</b> 1
	ЩВ <sup>(</sup>	ending				Bend	Ш	Grain			Ovalized		Pressure/Forced
	L C	entre No	t Concer	ntric to	o/s	BOM/Route	Ш	Hardwa	re		Over/Under	tolerance	Temperature/Cure
	∐Ci	racks				Broken/Damaged	-	•	ion Incomplete		Part Incorred	ct	Weld
•	Crushed/Crimped Burrs				Burrs	Ш	Instruct	tions Incomplete/	/Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled	
	Cuffs Contamination				Contamination	Ш	Mainte	nance		Part Moved			
	Heat Treat Countersink				Countersink	Ш	Mislabe	:led	<u> </u>	Positioned V	Vrong	<del>_</del>	
	Inspection Strip in Tube Cut Too Short					Ш	Misread	1	L	Power Loss/	Surge	Other	
	Ripples in Bend Drill Holes				Drill Holes	Ш	Offset						
Torque Waves in Extrusion Drawing				Drawing		Out of 0	Calibration						
Turning Sequence Finish				Finish	Out of Sequence								
	Wave/Twist in Tube				.	Folio		Outside Dimensions					

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Work	Order	· ID	111	<b>594</b>
WORK	Oraer	' ID	111	.594

January-15-14			*111594*									Page 2
Item ID: Revision ID: Item Name:	D3537-1 Wearpad			Accept	*N900	040	100	ገ*	Setup	Start Stop	· 1 V.	S1* S2*
Start Date: Required Date Reference:	1/15/14 : 2/07/14	Start Qty: 50.00 Req'd Qty: 50.00	*50* *50*		Cust Item :							
Approvals:		lan:	Date:	Tooling: SPC (Y/N):		ate:			Run	Start Stop	^ \	R1* R2*
Sequence ID/ Work Center I 130 *120* Brake NC Brake NC	D	Operation Description  NC BRAKE  Memo 1-Form as p Identify as I	er Dwg D3537 on CNC br D3537-1	Set Up/ Run Hours 0.00 0.00 ake using Jigs DT 8261 a	Tool ID	3	Plan Code AS 30 -89	Accept Qty	t Rej Qty		Reject Number	Insp. Stamp  (4(o)(2)
140 *140* Large Fab Large Fab		Large Fab  Memo Otty 127 456 weld that pe	cription Bate _1-Weld as per Dwg D353' enetrated through Wearpad	0.00  0.00  hA/R 2059B Hard rusing Jig DT 82102-Refinecessary	dcoat emove any	(3	98)	NS [	, (C		4 <u>-/-3</u>	
150 *150* QC Quality Control		QC10- Inspect visual pe	r QS1004- ground welds	0.00			(	50	1 <u>4.C</u>	<u>X-3</u> 1		DAS 9 9-89

	• •	,	
NCR:	Yes	/	No

## WORK ORDER NON-CONFORMANCE / UPDATE

DQA: ALDate: 14-2-24	•
A Closed: OXII - Date: 14-2-12	

QA Closed.   Date.   7 2.   7												
Work Order:	1115	594	4		DISPOSITION				AGAINST DE		' 1( ~	
Part No.	D38	537	-		Rework Scrap  Use-as-is Work Order Update		Therm	Skid-tube  Machining  noforming  Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	otion of work order update	lr	nitial	Ad	ction	Sign &		
Cause	Date	Step	Qty	(	or Non-conformance	Chi	ef Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator	403	cuj	١	hole	er apply to much and made a in wearped		DAS 16 9-89	screp	a gashod	CC 14-2-3	DAS 16 9-89	DAS 16 9-89
Setup Other Process	etup (hole process adayu				\	l	2042	ensure all + Pelomed co	troining in	EB. 11.2014	14/02/05	14/02/05 a>2042
Supplier Training X Unapproved	57							\$37	.49			
					F.	AUL'	CATE	GORY				
Landing	Gear				General					-	<del></del>	<del>-</del>
	Bending Centre No	ot Concei	ntric to	o/s	Bend BOM/Route		Grain Hardwa	-		Ovalized Over/Under	<del>-</del>	Pressure/Forced Temperature/Cure
-	Cracks	C		<b>-</b>	Broken/Damaged			ion Incomplete ions Incomplete	/Unclose	Part Incorred Part Lost/Mi	<del> </del>	Weld Wrong Stock Pulled
<b> </b>	Crushed/Crimped				Burrs Contamination	Н		nance	- Inclear	Part Moved	122111B	I wrong stock Pulled
Cuffs Heat Treat				-	Countersink	Н	Mislabe		<u> </u>	Positioned V	Vrong	
<b> </b>	Tube	 	Cut Too Short	$\vdash$	Misread		<u> </u>	Power Loss/		Other		
Inspection Strip in Tube Cut Too Sho Ripples in Bend Drill Holes					4	$\vdash$	Offset	-	<u>.                                    </u>	J. 5c. 2555/		1
1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1					Drawing	$\vdash$		Calibration				
Turning Sequence Finish					1	$\boldsymbol{\vdash}$		Sequence				
Wave/Twist in Tube					Folio	Outside Dimensions						

Work Orde		1594			23								
Item ID: Revision ID:	D3537-1			Accept	*N900	040	1100	)*	Setup	Start	*N	S1*	
Item Name:	Wearpad									Stop	*N	S2*	
Start Date: Required Date: Reference:	1/15/14 2/07/14	Start Qty: 50.00 Req'd Qty: 50.00	*50* *50*		Cust Item I Customer:	D:			_	G:		( )/	
Approvals:	Process Pla	an:	Date:	Tooling:	Da	ate:			Run	Start	*N	<b>R1</b> *	
	QC:		Date:	SPC (Y/N):	Da	ate:				Stop	*N	R2*	
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	t Re		Reject Number	Insp. Stamp	
160		QC5- Inspect part compl	eteness to step on W/O	0.00									
*160* QC Quality Control		Мето		0.00				(अ)	<u>) 10</u>	18:10:	<b></b>	DAS 9-89	
170		Grey Sandtex(Ref:4.3.5.6	5) per QSI005 4.3	0.00				(دوست		<i>u. (</i> .			DAS 34
*170* Powdercoat		//// <i>FSO</i> Memo		0.00				09	Ø	14-3	2-3		_ <b>_</b>
Powder Coating		START TW	ie: 230	OVEN TEMPERATURE	3:								

180

QC3- Inspect Part Finish

\*1 20\*

Memo

Quality Control

										DQA:	Date	:
NCR: Y	es / No				WORK ORDER NON-C	100	<b>NFORM</b>	MANCE / UPI	DATE			
							<b></b>			QA Closed:	Date	:
Work Orde	vr.				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
WOIK OIGE					Rework	1		Skid-tube	Crosstube	]	Water Jet	Engineering
Part N	lo.				Scrap	1		Machining	d. Eng. Coor.	Quality		
					Use-as-is	1	Thern	noforming	Finishing	1	re/Packaging	Other
NCR N	lo				Work Order Update	]		Large Fab	Composite	]	Supplier	
Root				Descri	ption of work order update	1	Initial	Act	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling												
Operator			1									
Material			1									
Setup												
Other												
Process		İ	į į			1						
Supplier	1											
Training												
Unapproved												
					F	AUL	T CATE	GORY				
Landir	ng Gear				General		_			_		
	Bendin	g			Bend		Grain			Ovalized		Pressure/Forced
	Centre	Not Conce	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	Weld
	Crushe	d/Crimped			Burrs		Instruct	ions Incomplete/l	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination	Mainte	enance		Part Moved	_	_	
	Heat Treat Countersink					Mislabeled			Positioned V	Vrong		
	Inspection Strip in Tube Cut Too Short					H H				Power Loss/	Surge	Other
	Ripples	in Bend			Drill Holes	Offset				_	_	

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence
Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

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			-										
Work Ord January-15-14		1594			*111					Page 4			
Item ID: Revision ID: Item Name:	D3537-1 Wearpad				Accept	*N900	<b>040</b>	100	<b>*</b> \$	Setup	Start Stop	171.	S1* S2*
Start Date: Required Date Reference:	1/15/14	Start Qty: 50.00 Req'd Qty: 50.00		*50* *50*		Cust Item I Customer:	D:						
Approvals:	Process Pl	an:	Date:_ Date:_		Tooling: SPC (Y/N):		ate:		]	Run	Start Stop	^1\11	R1* R <i>2</i> *
Sequence ID/ Work Center I  190  *100* Packaging Packaging	D	Operation Description Identify as per dwg & Sto	ck Locatio	n: <u>F(<sup>2</sup>-</u> 0C	Set Up/ Run Hours >\ 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp

200

QC21- Final Inspection - Work Order Release

0.00

\*200\*

Quality Control

Memo

0.00

ML5 14-02-04

NCR: Y	es / No				WORK ORDER NON-C	O	NFORI	MANCE / UPI	DATE	QA Closed:	Date:	
Work Orde	aŕ.				DISPOSITION				AGAINST DE			
Part N	lo.				Rework Scrap Use-as-is Work Order Update	Machining Small Fab Prod. Eng. Coor. Thermoforming Finishing Rec/Store/Packaging ate Large Fab Composite Supplier						
Root				Descri	ption of work order update	ŀ	nitial	Act	tion	Sign &		
Cause	Date	Step	Qty	(	or Non-conformance	Ch	ief Eng	Desci	ription	Date	Verification	QC Inspector
Doc/Data												İ
Equip/Tooling		1										
Operator												
Material												
Setup	_			]								
Other +												
Process	_			Ì								
Supplier						:						
Training								:				
Unapproved			<u> </u>	<u> </u>		<u> </u>	TCATE	CORY			<u> </u>	
					<del></del>	AUL	T CATE	GURT				
Landii	ng Gear Bending				General Bend		Grain			Ovalized		Pressure/Forced
		s Not Conce	ntric to	~  -	BOM/Route	$\vdash$	Hardwa			Over/Under	toloranco	Temperature/Cure
		VOI CONCE	iitiic to	<sup>0</sup> ,3 ⊢	d '	$\vdash$		ion Incomplete		Part Incorre	<u> </u>	Weld
	Crushed/Crimped Broken/Damaged					$\vdash$	1	tions Incomplete/l	Linclear —	Part Lost/Mi		Wrong Stock Pulled
	Crushed/Crimped Burrs Cuffs Contamination						Mainte	•		Part Moved		Jamon's stock i alica
	Heat Treat Countersink					-	Mislabe			Positioned V	Vrong	
	Inspection Strip in Tube Cut Too Short						Misrea		<del>                                     </del>	Power Loss/		Other
	Ripples in Bend Drill Holes						Offset	<del>-</del> -		1. 22. 2300/		1 =
Torque Waves in Extrusion Drawing					Out of Calibration						·	
Turning Sequence Finish							ł	Sequence				
		wist in Tu			Folio		1	Dimensions				

DQA:

Date:

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January-15-14 1:19:04 PM

Work Order ID:

111594

Parent Item:

D3537-1

**Parent Item Name:** 

Wearpad

**Start Date:** 1/15/14

Required Date: 2/07/14

**Start Qty:** 50.00

Required Qty: 50.00

**Comments:** 

IPP Rev:A

New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	302.6470	0.106	5 <del>.578945</del>		A	,
304/316 Sheet .063											9	Se 14	01.26

Location Loc Qty Loc Code MAT020 302.647 M126915 7.147 M127821 295.5

127821 -> 5.5 6.5

											DQA:	Date	:
NCR:	Yes	/ No				WORK ORDER NON-O		NFORM	MANCE / UP	DATE			,
											QA Closed:	Date	
Work Ord	or.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
WOIK OIG	C1.					Rework	1		Skid-tube	Crosstube	1	Water Jet	Engineering
Part i	Nο					Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
, are					<del></del> -	Use-as-is	1 1	i	noforming	Finishing	4	re/Packaging	Other
NCR	No.					Work Order Update	1		Large Fab	Composite	1	Supplier	1
					··	'	•			· L	<b>4</b> ,		
Root					Descri	ption of work order update		Initial	Ac	tion	Sign &		
Cause		Date	Step	Qty	(	or Non-conformance	Ch	ief Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling							1						
Operator		•											
Material													
Setup													
Other	<u> </u>		1										
Process		ļ	Ì										
Supplier	<u></u>						İ						
Training													1
Unapproved	L		<u> </u>	<u> </u>									
						·	AUI	T CATE	GORY				
Land	ing (	1				General	_	7			7		<b>-</b>
	<b></b>	Bending				Bend		Grain		<u> </u>	Ovalized		Pressure/Forced
	Centre Not Concentric to O/S			BOM/Route	<u> </u>	Hardware			Over/Under		Temperature/Cure		
	_	Cracks				Broken/Damaged	$\vdash$	1	ion Incomplete		Part Incorre	<u> </u>	Weld
1		Crushed/	'Crimped			Burrs	<b>—</b>	4	ions Incomplete,	/Unclear	Part Lost/M	ssing	Wrong Stock Pulled
	_	Cuffs				Contamination	$\vdash$	Mainte			Part Moved		
,	$\vdash$	Heat Trea	at			Countersink	_	Mislabe		<u> </u>	Positioned V		¬
1	1	Inspectio	n Strip in	Tube	1	Cut Too Short	1	Misread	<u> </u>	<b>!</b>	Power Loss/	Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence
Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

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DART AEROSPACE LTD	Work Order:	111594
Description: Wearpad	Part Number:	D3537-1
Inspection Dwg: D3537 Rev: C		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments		
4.250	+/-0.010	4.254	-		V	JKM-05		
3.500	+/-0.010	3.500	1		V			
1.965	+/-0.010	1,965	1		V			
2.795	+/-0.010	2,795			V			
3.625	+/-0.010	3.625	_		V			
0.220 x 0.380	+/-0.010	218x.378	_		V			
				•				
			,					
		1						

Measured by:	Audited by:	16	Prototype Approval:	N/A
Date: 14.01	Date:	1-11-1177	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	07.03.21	New Issue	KJ/JLM	
В	07.04.27	Dimensions revised per Dwg Rev. B	KJ/JLM	1
С	07.05.28	Dimensions revised per Dwg Rev. C	KJ/JLM	adl
			77	7~7

